

Date: Thursday, 07/08/2008 12:58:50 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D412-742-013
 Job Number : 41048
 Estimate Number : 10804
 P.O. Number :
 This Issue : 07/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LANDING GEAR
 Previous Run : 41046
 Part Number : D412742013
 Drawing Number : DSI 9369/ECN08-510 / *RM 08-071*
 Project Number :
 Drawing Revision :
 Material :
 Due Date : 14/08/2008 Qty: 1 Um: Each
 Written By : *W*
 Checked & Approved By :
 Comment :

Additional Product

Job Number:

**DART**

TRANSPORT CANADA APPROVAL # 08-89

TEL: 1-613-632-3336
FAX: 1-613-632-4443

P/N	D412-742-013	CHG	CHG003
DESC	Float Skidtube	STC	SR01583SE
LOV	B37973	STC	SH05-37
MODEL	205/210/212/412/AB412	STC	

US PATENT # 6,735,864
CANADA FOREIGN PATENTS PENDING

MADE IN CANADA

Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STK:

D412-742-013 B *37973*

2.0 D412742013 Float Skidtube Installation



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Float Skidtube Instln

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

REMOVE END CAPS BOTH ENDS
TO REMOVE/CLEAN LPS FROM TUBE

FORWARD TUBE TO SKIDTUBE CELL

Feb 08/08/08 (1)

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

A) - DRILL 0.500 DIAM. HOLES THRU D3391-021 FWD TUBE AND D3391-023 MID TUBE(2 PLACES) AS SHOWN ON DSI 9364.

INSTALL D3591-1 BUSHING B *31514*B) - DEBURR ALL HOLES
- TOUCH UP ALODINE
- TOUCH UP PAINTC) - RECOAT WITH LPS3 B *M1107912 08-08-10 (2)*
888
(PW)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-742-013 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: JA Date: 08.08.21
 QA: N/C Closed: A Date: 08/20/24

NCR: <u>41048</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08.08.14</u>	<u>4.0</u>	<u>The aft cap 02646 was damaged @ the insert area when it was removed from the tube.</u>	<u>[Signature]</u>	<u>scrub & replace. Qty 1</u> <u>B 37755</u>	<u>[Signature]</u> <u>08.08.14</u> <u>(RT)</u>	<u>[Signature]</u> <u>08/08/14</u>	<u>[Signature]</u> <u>08/08/14</u>	<u>[Signature]</u> <u>08-08-14</u>

NOTE: Date & initial all entries

Date: Thursday, 07/08/2008 12:58:50 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D412-742-013

Job Number: 41048

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35911

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
BUSHING

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REINSPECT KIT FOR 100% COMPLETENESS

08/08/18
B37973 35744 8/8/18

(A)

SP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP USING NEW B/N.
NEW PAPERWORK & LABELS REQ'D
CHG 005
-ENSURE DSI PAPERWORK ADDED

8/8/18

SV

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2018

Job Completion



MF 08-08-19

B 41048


W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN PH	DRAWN BY AJS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED	DRAWING NO. DSI 9364	REV. C SHEET 1 OF 1
DATE 08.08.06	TITLE BUSHING INSTALLATION		SCALE NTS
A	07.01.16	NEW ISSUE	
B	07.03.20	ADD TOLERANCE TO 1/2" HOLE	
C	08.08.06	ADDED CHG 005 & SUBS TO EFFECTIVITY. TOLERANCE ON 1/2" HOLES WAS +0.006 -0.000	

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. B AND ICA-D412-742 REV. 1

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

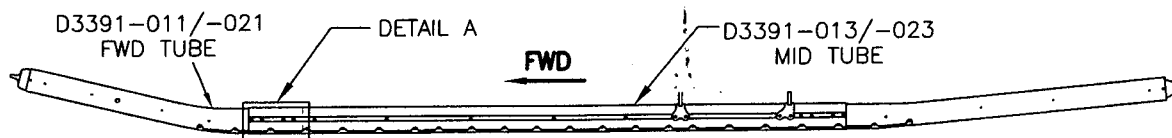
TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 OR CHG 005 AND SUBSEQUENTS HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001, CHG 003 AND CHG 004 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

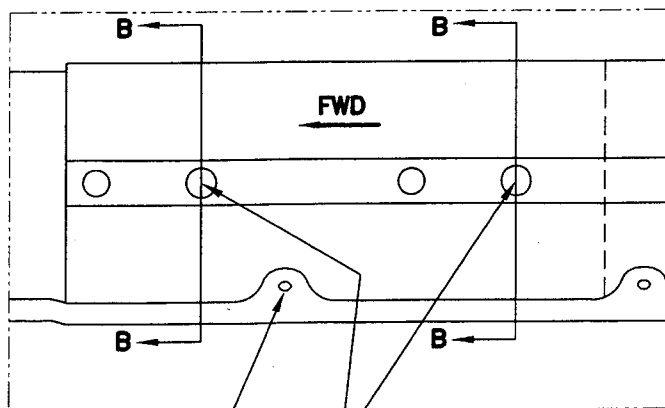
- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ($\varnothing 0.500 \pm \begin{smallmatrix} 0.002 \\ 0.000 \end{smallmatrix}$) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. **DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.**
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING

REFERENCE ONLY



D412-742-011/-013 SKIDTUBE SHOWN

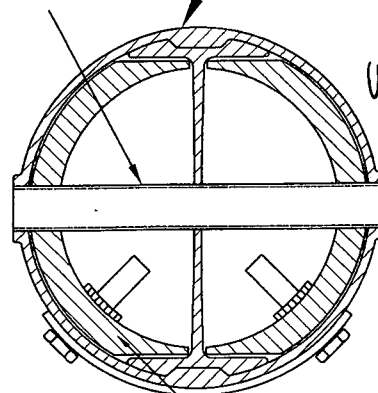


ENSURE BOLT IS FASTENED PRIOR TO TRANSFER DRILLING (REF)

OPEN TO $\varnothing 0.500 \pm \begin{smallmatrix} 0.006 \\ 0.000 \end{smallmatrix}$ AND INSTALL D3591-1 BUSHING (2 PLACES)

DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION

D3591-1 BUSHING
D3391-013/-023 MID TUBE



D3391-011/-021 FWD TUBE

SECTION B-B

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DESIGN PH	DRAWN BY AJS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. DSI 9364	REV. C SHEET 1 OF 1
DATE 08.08.06		TITLE BUSHING INSTALLATION	SCALE NTS
A	07.01.16	NEW ISSUE	
B	07.03.20	ADD TOLERANCE TO 1/2" HOLE	
C	08.08.06	ADDED CHG 005 & SUBS TO EFFECTIVITY	

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. D AND ICA-D412-742 REV. 3

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

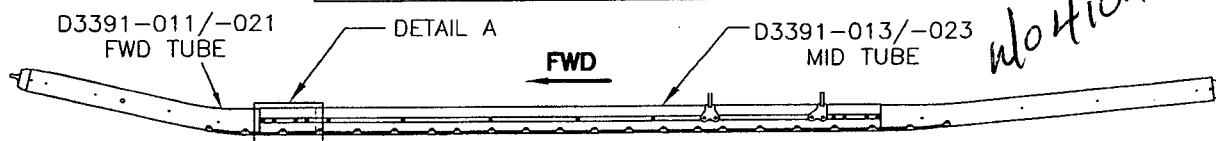
REF EASA STC: IM.R.S.01126

TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 OR CHG 005 AND SUBSEQUENTS HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

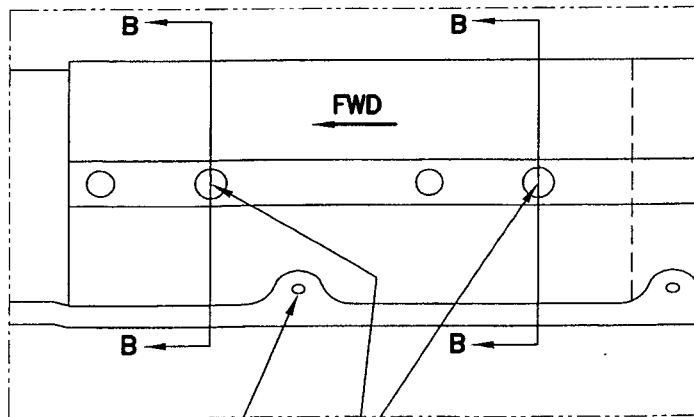
CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001, CHG 003 AND CHG 004 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ($\varnothing 0.500 \pm_{0.000}^{0.006}$) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. **DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.**
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING



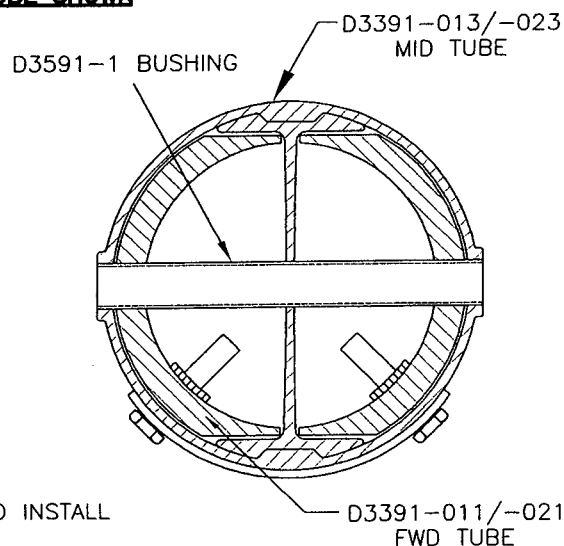
D412-742-011/-013 SKIDTUBE SHOWN



ENSURE BOLT IS FASTENED PRIOR TO TRANSFER DRILLING (REF)

OPEN TO $\varnothing 0.500 \pm_{0.000}^{0.006}$ AND INSTALL D3591-1 BUSHING (2 PLACES)

DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION



SECTION B-B

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